

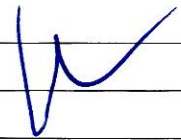
Work Order ID 164562

164562

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Friday, July 21, 2017 12:56:41 PM

Item ID: D3049-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 7/21/2017 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 8/18/2017 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3049	Rev B								

110 0.02
 110
 Waterjet Memo 1.81
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3049-1_BLANK
 10 17/07/21

120 1.38
 120
 HAAS 1 HAAS CNC VERTICAL MACHINING #1
 HAAS CNC vertical machine #1 Memo 4.29
 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
 3-Deburr
 10 2017/8/11
 DAS 45 49
 9-89 9-89
 2017-8-11

130 0.00
 130
 QC QC2- Inspect parts off machine FAI/FAIB
 Quality Control Memo 0.10
 10 2017/8/11
 DAS 45 49
 9-89 9-89
 2017-8-11

DAS 49 9-89

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Friday, July 21, 2017 12:56:41 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20				10			SLT-8-13
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>51466A</u> Packaging Memo	0.00 0.10				10			DAS 6 AUG 14 2017
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00							DAS 21 9-89 AUG 16 2017

LM 8/14/17  AUG 14 2017

Picklist Print

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Friday, July 21, 2017 12:56:39 PM

Work Order ID: 164562

164562

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 7/21/2017

Required Date: 8/18/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	519.5730	3.4	34			

MUHMWB10

**

07/21/17

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

519.573

m136453

200

m137449

319.573

36

DART AEROSPACE LTD		Work Order: 164562
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: B	Page 1 of 1

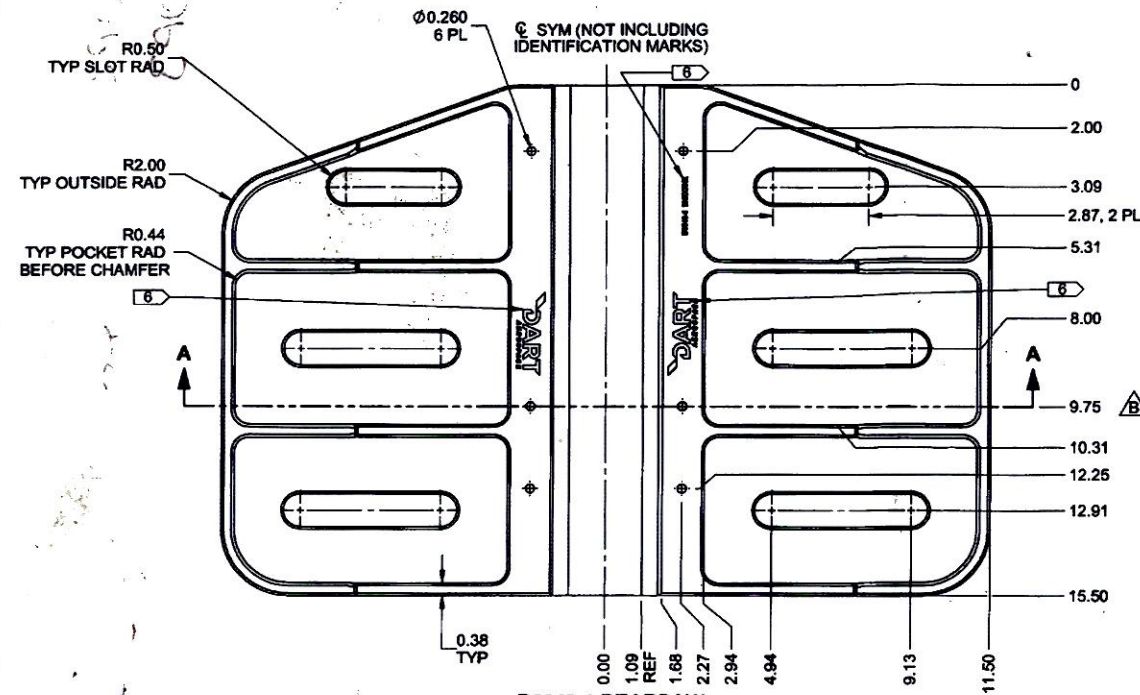
INSPECTION SHEET

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	.260 ✓	✓		Pin gage	
B	0.93	+/-0.030	.926 ✓	✓		Vern ML-06	
C	0.40	+0.030/-0.000	.415 ✓	✓		Vern ML-06	
D	2.00	+/-0.030	2.00 ✓	✓		Vern ML-06	
E	10.31	+/-0.010	10.309 ✓	✓		high gage	
F	2.87	+/-0.030	1.865 ✓	✓		Vern ML-06	
G	8.00	+/-0.030	8.001 ✓	✓		high gage	
H	0.38	+/-0.030	.379 ✓	✓		Vern ML-06	
I	11.50	+/-0.030	11.50 ✓	✓		Tape	
J	0.07 x 45°	+0.030/-0.010	.068 x 45°				
K	0.44 - 0.47	+/-0.000	.445 ✓	✓		Vern ML-06	
L	R0.25	+/-0.030	R0.25 OK ✓	✓		Radius gage	
M							
N	0.95	+0.030/-0.010	.945 ✓	✓		Vern ML-06	
O	0.69	+/-0.030	.69 ✓	✓		ML-60	
P	0.20	+/-0.030	.192 ✓	✓		JFC-08	
Q	R0.25	+/-0.030	R.25 ✓	✓		tape	
R	0.25 x 45°	+/-0.030	.25 x 45° ✓	✓		tape	
S							
T							
U							
V							
W							
X							
Y							
Z							
AA							
AB							

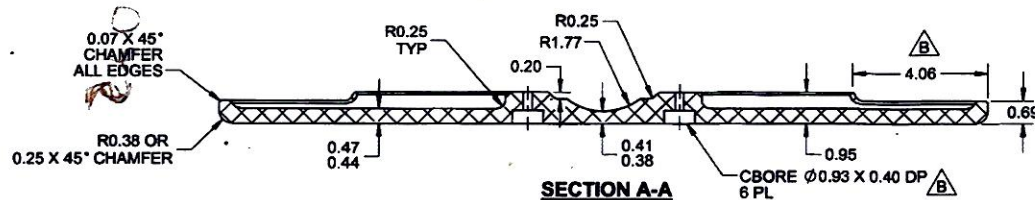
Measured by: M. 2017/8/14	Checked by: Jh	QC Inspector:
Date:	Date: 17-8-13	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	
C	16.10.20	Dwg Rev updated	KJ	



D3049-1 BEARPAW



SECTION A-A

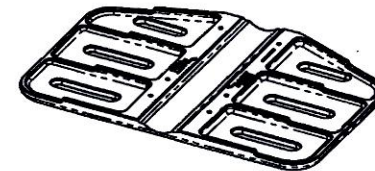
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.00 THICK MACHINED TO 0.95 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO, PART NUMBER "D3049-1" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3 TO MAX DEPTH OF 0.012 AS ILLUSTRATED
- 7) WEIGHT: 5.94 lbs
- 8) NON DIMENSIONED FEATURES PER CAD FILE "D3049-1-REV.B.STP"

RELEASED
2016-07-26
ECN 16-591

APPROVED

B	REVISE DWG TO CURRENT STANDARDS, ADDED 2 ADDITIONAL CBORE HOLES ZIN C6-1, UPDATE DIM'S DUE TO CAD ERROR; Ø0.93 WAS Ø0.75	ML	16.08.01
A	NEW ISSUE	RF	01.10.18
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ML		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3049	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BEARPAW	NTS
DATE	16.06.01	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



WLO 104562